

IN THE CLAIMS

Please amend the claims to read as follows wherein changes in a claim are shown by strikethrough for deleted matter and underlining for added matter:

1. (Currently Amended) Method for arranging a thermoplastic insert unit comprising a body and a flange having a larger cross-section than the body, in a thermoplastic sandwich product having at least one substantially planar section, which sandwich product comprises a layer of a thermoplastic foam core material and at least one covering layer formed from a fiber-reinforced thermoplastic, the method comprising the steps of forming a hole having a cross-section smaller than the flange in the covering layer of the thermoplastic sandwich product, with core material being removed; placing the thermoplastic insert unit in the hole; positioning the thermoplastic insert unit between a horn and an anvil of an ultrasonic apparatus; applying ultrasonic energy and pressure, so that heat is generated between the thermoplastic insert unit and the ~~fiber-reinforced~~ fiber-reinforced covering layer of the thermoplastic sandwich product; fixing the thermoplastic insert unit through cooling after sufficient heat has been supplied to allow fusion between the underside of the thermoplastic insert unit and the outer surface of the fiber-reinforced covering layer of the thermoplastic sandwich product.
2. (Previously Presented) Method according to claim 1, in which the sandwich product comprises a top covering layer formed from a fiber-reinforced thermoplastic, a thermoplastic foam core layer and a bottom covering layer formed from a fibre-reinforced thermoplastic.
3. (Cancelled)
4. (Previously Presented) Method according to claim 1, in which the dimensions of the hole are equal to the dimensions of the body of the thermoplastic insert unit.
5. (Previously Presented) Method according to claim 1, in which the body of the thermoplastic insert unit is matched to the thickness of the sandwich product such that application of ultrasonic energy and pressure effects simultaneous fusion of the underside of the

thermoplastic insert unit to the top side of the bottom covering layer and the underside of the flange of the thermoplastic insert unit to the top side of the top covering layer of the thermoplastic sandwich product.

6. (Currently amended) Method according to claim 1 for arranging a thermoplastic insert unit comprising a body and a flange having a larger cross-section than the body, in a thermoplastic sandwich product having at least one substantially planar section, which sandwich product comprises a layer of a thermoplastic foam core material and at least one covering layer formed from a fiber-reinforced thermoplastic, the method comprising the steps of forming a hole having a cross-section smaller than the flange in the covering layer of the thermoplastic sandwich product, with core material being removed; placing the thermoplastic insert unit in the hole; positioning the thermoplastic insert unit between a horn and an anvil of an ultrasonic apparatus; applying ultrasonic energy and pressure, so that heat is generated between the thermoplastic insert unit and the fiber-reinforced covering layer of the thermoplastic sandwich product; fixing the thermoplastic insert unit through cooling after sufficient heat has been supplied to allow fusion between the underside of the thermoplastic insert unit and the outer surface of the fiber-reinforced covering layer of the thermoplastic sandwich product, in which the covering layer is notched at the position of the hole to be made, a hole is provided in the thermoplastic foam core material and the covering layer is folded into the hole.

7. (Cancelled)

8. (Currently Amended) Method according to claim 1, also comprising a step of forming a recess by deformation in a surface of the thermoplastic sandwich product before a thermoplastic insert unit is placed in the hole formed in the covering layer the, recess configured to receive the flange of the thermoplastic insert unit.

9. (Previously presented) Method according to claim 8, in which the recess is applied using a deformation method.

10. (Previously Presented) Method according to claim 9, in which the recess in the top covering layer of the thermoplastic sandwich product is reinforced with an additional fibre-reinforced thermoplastic layer.

11. (Cancelled)

12. (Previously Presented) Method according to claim 1, wherein said cooling is performed under pressure.

13. (Previously Presented) Method according to claim 5, wherein less than 90% of the thermoplastic foam core to be occupied by the thermoplastic insert unit is removed.

14. (Currently Amended) Method according to claim 9 for arranging a thermoplastic insert unit comprising a body and a flange having a larger cross-section than the body, in a thermoplastic sandwich product having at least one substantially planar section, which sandwich product comprises a layer of a thermoplastic foam core material and at least one covering layer formed from a fiber-reinforced thermoplastic, the method comprising the steps of forming a hole having a cross-section smaller than the flange in the covering layer of the thermoplastic sandwich product, with core material being removed; placing the thermoplastic insert unit in the hole; positioning the thermoplastic insert unit between a horn and an anvil of an ultrasonic apparatus; applying ultrasonic energy and pressure, so that heat is generated between the thermoplastic insert unit and the fiber-reinforced covering layer of the thermoplastic sandwich product; fixing the thermoplastic insert unit through cooling after sufficient heat has been supplied to allow fusion between the underside of the thermoplastic insert unit and the outer surface of the fiber-reinforced covering layer of the thermoplastic sandwich product, also comprising a step of forming a recess in a surface of the thermoplastic sandwich product before a thermoplastic insert unit is placed in the recess, in which the recess is applied using a deformation method, wherein the deformation method comprises a step of placing a deformation stamp having a temperature in the range of the melting point $\pm 10\%$ of the thermoplastic of the fiber-reinforced thermoplastic covering layer, on the fiber-reinforced thermoplastic covering layer under pressure and for a time sufficient to allow plastic deformation and melting of the top covering layer and the core, then

placing a consolidation stamp having the final shape of the recess at a temperature in the range of 70-100% of the glass transition temperature of the thermoplastic in the fiber-reinforced thermoplastic covering layer under pressure on the deformed fiber-reinforced thermoplastic covering layer and allowing the recess to cool to below the glass transition temperature of the thermoplastic in the fiber-reinforced thermoplastic covering layer.